

Date: Thursday, 6/15/2006 1:52:16 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 27597	
Estimate Number : 10533	
P.O. Number : N/A	Part Number : D2573
This Issue : 6/15/2006 S.O. No. : N/A	Drawing Number : D2573 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 27058	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 6/30/2006
Checked & Approved By : JG 06.06.15	Qty : 12 Um : Each
Comment : Est: 1 As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2573

Ensure that grain is along 7.75" length

Batch No: B 24070

J.G 06/06/19 X12

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 27597 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

J.G 1/CP 06/06/25 X12

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

J.G 1/CP 06/06/25 X12

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 1/CP 06/06/25 X12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/30

NOTE: Date & initial all entries

QA: N/C Closed: ☒ Date: _____

Date: Thursday, 6/15/2006 1:52:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27597

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

m/06/06/26

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06-06-28

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

P.M 06-06-29

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P/06/6/29

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 480*

H.M 06-06-29

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/06/30

(12)

Job Completion



W 06-06-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 27597
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.751	1.747	1.747	1.748		
C	3.495	3.505		3.498	3.496	3.497	3.498		
D	1.745	1.755		1.751	1.747	1.747	1.748		
E	7.990	8.010		8.001	8.000	8.002	8.001		
F	0.490	0.510		0.498	0.494	0.497	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.496	0.497	0.497		
J	1.174	1.184		1.175	1.177	1.177	1.178		
K	0.558	0.578		0.562	0.566	0.567	0.569		
L	1.174	1.184		1.175	1.177	1.177	1.177		
M	1.365	1.375		1.368	1.368	1.368	1.367		
N	2.495	2.505		2.497	2.498	2.497	2.498		
O	4.119	4.129		4.126	4.124	4.120	4.121		
P	0.115	0.135		0.127	0.129	0.127	0.128		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.254	0.253	0.254		
S	0.115	0.135		0.128	0.128	0.127	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.236		
V	0.230	0.250		0.238	0.238	0.237	0.238		
W	0.115	0.135		0.127	0.126	0.127	0.126		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.366	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.635	0.635	0.634		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.244		
AE	1.500	1.520		1.513	1.515	1.513	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.247	0.246		
AI	2.000	2.020		2.003	2.005	2.003	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.026		
Accept/Reject									

Measured by: <u>EP / J.G</u>	Audited by: <u>JML</u>
Date: <u>06/06/23</u>	Date: <u>06/06/26</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 27597
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.748	1.748	1.747	1.746		
C	3.495	3.505		3.499	3.499	3.499	3.499		
D	1.745	1.755		1.748	1.748	1.747	1.746		
E	7.990	8.010		8.000	8.000	8.004			
F	0.490	0.510		0.500	0.501	0.496	0.496		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.499	0.497	0.500	0.495		
J	1.174	1.184		1.179	1.178	1.177	1.176		
K	0.558	0.578		0.568	0.568	0.562	0.562		
L	1.174	1.184		1.179	1.179	1.177	1.176		
M	1.365	1.375		1.369	1.368	1.365	1.366		
N	2.495	2.505		2.499	2.499	2.495	2.496		
O	4.119	4.129		4.121	4.121	4.122	4.121		
P	0.115	0.135		0.130	0.131	0.126	0.125		
Q	0.115	0.135		0.129	0.128	0.125	0.135		
R	0.240	0.260		0.250	0.249	0.253	0.252		
S	0.115	0.135		0.130	0.130	0.127	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.246	0.241	0.237	0.238		
W	0.115	0.135		0.122	0.124	0.122	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.765	0.765		
Z	0.352	0.372		0.364	0.364	0.364	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.631	0.629	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.244		
AE	1.500	1.520		1.511	1.510	1.513	1.512		
AF	0.115	0.135		0.130	0.131	0.135	0.135		
AG	0.240	0.280		0.245	0.244	0.260	0.260		
AH	0.240	0.260		0.253	0.253	0.246	0.245		
AI	2.000	2.020		2.000	2.001	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G / E
Date: 06/06/24

Audited by: Jm
Date: 06/06/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27597
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.441	0.441	0.441		
B	1.745	1.755		1.746	1.749	1.748	1.749		
C	3.495	3.505		3.497	3.499	3.497	3.499		
D	1.745	1.755		1.746	1.749	1.748	1.749		
E	7.990	8.010		8.002	8.003	8.001			
F	0.490	0.510		0.497	0.498	0.497	0.502		
G	0.257	0.262	DT8683	0.258	0.259	0.257	0.259		
H	0.375	0.380	DT8684	0.376	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.499	0.501	0.498		
J	1.174	1.184		1.176	1.178	1.176	1.177		
K	0.558	0.578		0.566	0.563	0.566	0.565		
L	1.174	1.184		1.176	1.178	1.176	1.177		
M	1.365	1.375		1.367	1.368	1.367	1.367		
N	2.495	2.505		2.497	2.497	2.499	2.497		
O	4.119	4.129		4.120	4.120	4.122	4.121		
P	0.115	0.135		0.126	0.123	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.249	0.252	0.254		
S	0.115	0.135		0.121	0.120	0.120	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.232	0.236	0.237	0.237		
W	0.115	0.135		0.131	0.125	0.122	0.122		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.365	0.367	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.633	0.633	0.632	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.250	0.244		
AE	1.500	1.520		1.512	1.511	1.513	1.515		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.246	0.246	0.248		
AI	2.000	2.020		2.002	2.001	2.002	2.005		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G/En
Date:	06/06/25

Audited by:	J.V
Date:	06/06/2020

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

0.000

VIEW B-B

1.73

0.20

2

R0.66 (TYP)

R0.50 (TYP)




DART

1.750 ± 0.005

3.500 ± 0.005

1.750 ± 0.005

8.000

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS	PH	
HARRISBURY, ONTARIO, CANADA		DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.
		D2573
DATE	TITLE	
05.07.13	OUTER AFT SADDLE	
REV.		SHEET 1 OF
SCALE		2

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WORK ORDER
NO. 27597

